

Work Order ID 66914

Wednesday, March 02, 2011 2:32:28 PM



Page 1

Item ID:	D3838-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly (Basket Lid, RH)					
Start Date:	3/2/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	3/8/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-2	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3838	Rev A								

100	Large Fab	0.00
	Large Fab	0.00
Large Fab	Memo	
	1- cut D3838-2 and D3838-3 rib as per dwg D3838	
	2- remove identification markings	
	3- deburr	
	4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838	
	A/R ER316 S.S. Rod Batch: 115928	
	5- c'sink hole as per dwg	
	6- grind weld flush where indicated on dwg D3838	
	7- weld D3759-1 bushing as per dwg D3838	
	A/R ER316 S.S. Rod Batch: 115928	
	8- grind bushing weld flush as per dwg dwg D3838	
	9- deburr hole if necessary	

SAD 11-03-05

②

BE
Pto →
PL 11-03-14 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3838-042 PAR #: _____ Fault Category: Change Parts NCR: Yes No DQA: 11/03/15 Date: 11/03/15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/03/29 Date: 11/03/29

NCR: <u>66914</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/03/15</u>	<u>#10091</u>	Found at inspection that D3838-3 was cut wrong. The angled ends were cut in the incorrect orientation to them selfs. + was welded.	<u>[Signature]</u>	- SCRAP? replace. Qty 1 D3838-3 B <u>116267</u>	<u>SAD</u> <u>11-03-20</u> <u>[Signature]</u>		<u>[Signature]</u>	<u>[Signature]</u> <u>11/03/15</u>
		R.C. Lack of Attention when cutting.						<u>[Signature]</u> <u>11/03/15</u>



NOTE: Date & initial all entries




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Page 2

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Required Date:	3/8/2011	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo 6/10/123	0.00 0.00 (42)	BE 11-03-15	15		2	0		
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00	BE 11-03-15	23		2	0	BE 11/03/15 BE 11/03/23	
130  Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00	SAD 11-03-23				(2)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66914

Wednesday, March 02, 2011 2:32:28 PM

Page 3

Item ID: D3838-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 3/2/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/03/29
MF
11-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 02, 2011 2:32:34 PM

Page 1

Work Order ID: 66914

Parent Item: D3838-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 3/2/2011



Required Date: 3/8/2011

Start Qty: 2.00

Required Qty: 2.00



Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	243.0000	1	2			
													
Bushing													

Location Loc Qty Loc Code

ST084	2	
66125	2	
WA	241	
54072	9	
66107	42	
66489	190	

M304TS0.750W.065		Purchased	No			100	f	1,309.455	1.0317	2.172			
													
304 SQ Tube .75x.75x.065W													

Location Loc Qty Loc Code

MAT	1309.4551	
112398	0	
116267	309.4551	
116763	1000	

②
SAD 11-03-03
END Scrmp
2.172 + 1.00 = 3.172

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

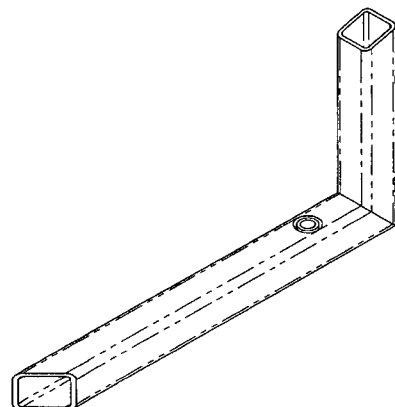
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

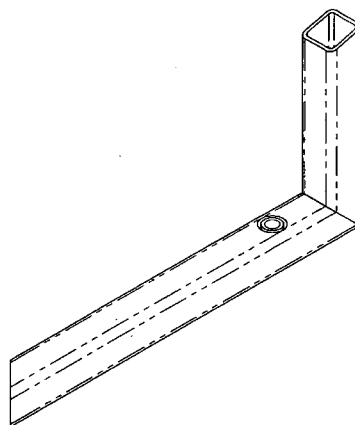
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66914

2811-03-2

RELEASED
08/11/08

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3838** REV. A
SHEET 1 OF 3

TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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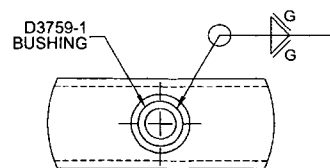
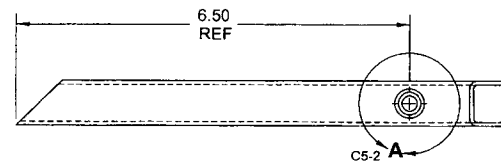
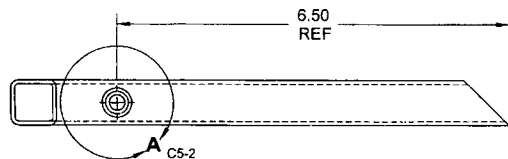
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

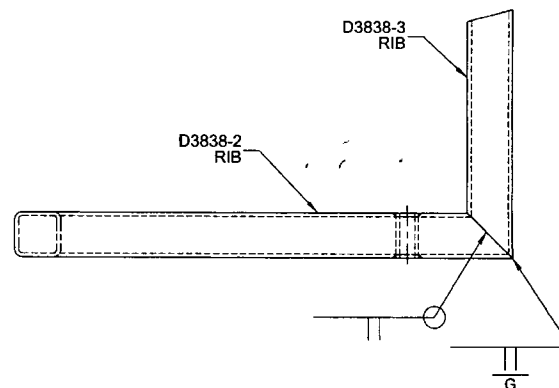
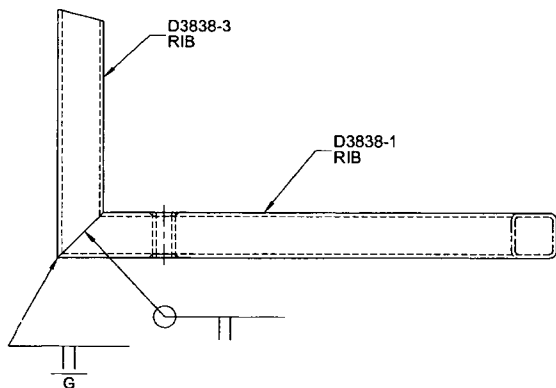
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NOTE: Date & initial all entries



DETAIL A
D2-2
D7-2 SCALE 2X



D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, LH)

RELEASED
08/10/08

W/O 66914

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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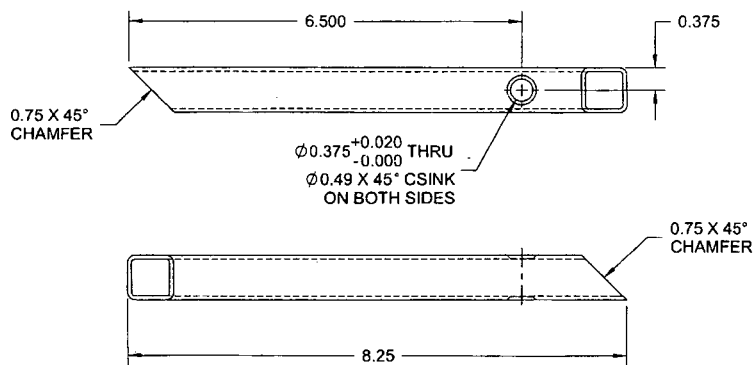
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

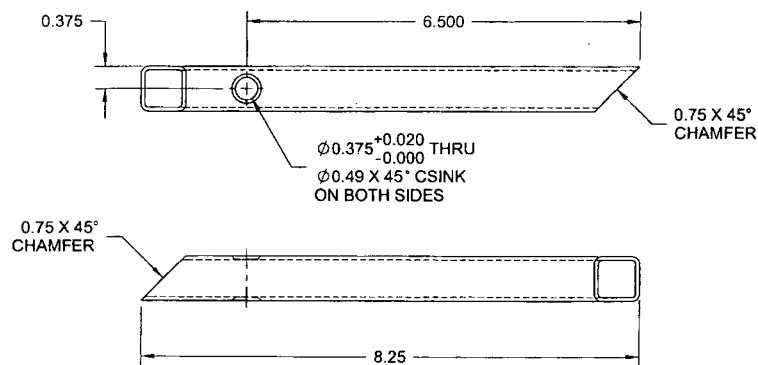
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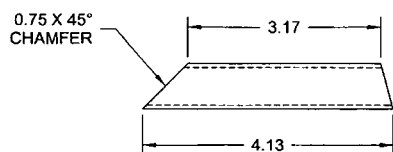
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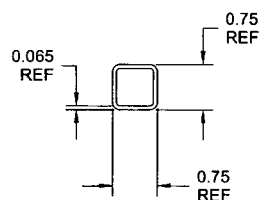
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

u/u 46914

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3838-1/2 = 0.35 lbs EACH; D3838-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3838	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

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